

Wednesday, July 08, 2015 3:12:55 PM

134402

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/10/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/10/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** MLS **Date:** JUL 09 2015 **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4840	REV A

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Packaging

Memo

120

120

Small Fab

Small Fab

Memo

Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: M131311

130

QC5- Inspect part completeness to step on W/O	0.00
---	------

130

QC

Quality Control

Memo

0.00

① 15.07.16 9
9.89

DAS
9
~~9-89~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 7/10/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/10/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

OC

Memo

0.00

Quality Control

JUL 19 2015

D
6
— 9.8

ML3

JUL 20 2015

MLC

JUL 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Picklist Print

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3

Work Order ID: 134402

134402

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 7/10/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4823-1 *D4823-1* Upper Cutter Deflector		Manufactured	No				Each	10.0000		1	DAS 30 9-89	JUL 14 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				10					
					105011			4					
					109244			6		1			
D4824-1 *D4824-1* Upper Cutter Mount		Manufactured	No				Each	5.0000		1	DAS 30 9-89	JUL 14 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				5					
					109245			5		1			
D4838-2 *D4838-2* Upper Cutter Body, RH		Manufactured	No				Each	5.0000		1	DAS 30 9-89	JUL 14 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				5					
					100677			1					
					109247			4		1			
D4838-1 *D4838-1* Upper Cutter Body, LH		Manufactured	No				Each	3.0000		1	DAS 30 9-89	JUL 14 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				3					
					109246			3		1			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 134402

134402

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 7/10/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

D4839-1 Manufactured No

Each 10.0000 2

DAS JUL 14 2015

D4839-1

30
9-89

Blade

Location

Loc Qty

Loc Code

MF

10

133453

10

2

MS27039-08-19

Purchased No

Each 524.0000

14

DAS

JUL 14 2015

MS27039-08-19

30
9-89

Screw

Location

Loc Qty

Loc Code

ST273A

438

m131317

438

ST281

86

m127904

3

m131264

83

14

NAS1149FN832P

Purchased No

Each 3,231.000

28

DAS

JUL 14 2015

NAS1149FN832P

30
9-89

Washer

Location

Loc Qty

Loc Code

ST260a

1732

125268

1732

st268

1499

125268

578

M130388

921

28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Misidentified ☐	Past Due ☐								

Picklist Print

Page 3

Wednesday, July 08, 2015 3:12:55 PM

Work Order ID: 134402

134402

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 7/10/15

Required Date: 7/10/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

926.0000

14

DAS
30
9-89

JUL 14 2015

MS21042L 08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

501

m131697

501

ST304

324

123900

16

m128401

102

m128429

3

m131317

203

14

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																							
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																							
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																							
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																							
Past Expiry Date ☐	Manufacturing Process ☐																																																																											
Misidentified ☐	Past Due ☐																																																																											

ITEM	QTY -041	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4836-1	UPPER CUTTER BODY LH
4	1	D4838-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN960C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT

NAS1149FN832P WASHER

D4823-1 UPPER CUTTER DEFLECTOR

D4839-1 BLADE

D4836-1 UPPER CUTTER BODY LH

NAS1149FN832P WASHER

MS27039-0819 SCREW

MS21042L08 LOCK NUT

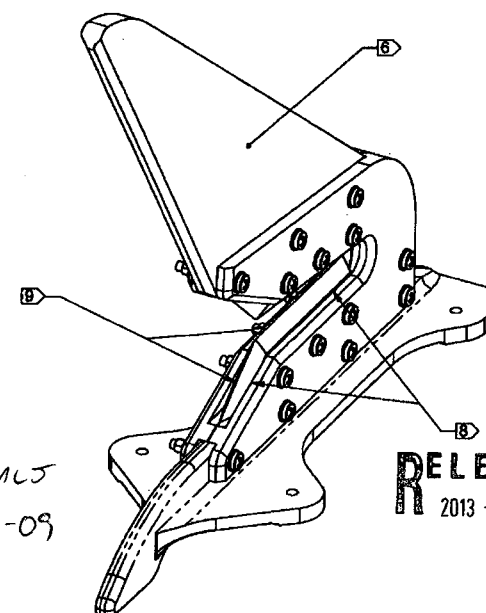
D4838-2 UPPER CUTTER BODY RH

D4824-1 UPPER CUTTER MOUNT

SHOWN COPY
RETURN TO
TO ORDERING
UNLESS OTHERWISE NOTED
SUPPLIER'S COPY ONLY
WILL BE USED
WORK ORDER

134402 MJS

15-07-09



RELEASED
2013-07-12
JMD

D4840-041 UPPER CUTTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS).
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

A		NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4840 TITLE UPPER CUTTER ASSY COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
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MFG. APPR.	AP				
APPROVED	AP				
DE APPR.	AP				
DATE	13.05.23				
		DRAWING NO.	REV.		
		D4840	SHEET 1 OF		
		TITLE	SCALE		
		UPPER CUTTER ASSY	NT		